

Work Order ID 82386

82386

Page 1

March-30-12 7:46:29 AM

Item ID: D2666-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, LH Fwd Aft In 206

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/30

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2666

Rev D

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

FK. 12/06/25

10

0

HAAS CNC vertical machine #1

Program batch number.1- Inspect part number and batch number are programmed correctly.2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

PD 12/06/26

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

PD

12/06/27

10

0

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

FK. 12/06/25

PD 12/06/26

10

0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82386

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Item ID: D2666-1

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, LH Fwd Aft In 206

Stop

NS2

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-06

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 mlb 12-6-28

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7h05

OVEN TEMPERATURE:

m120 222

320°F FINISH TIME:

7h35

10 Q 2P 12/06/19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82386

March-30-12 7:46:29 AM

82386

Page 3

Item ID: D2666-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, LH Fwd Aft In 206

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

10 0 12/12/3.

P 12/7/03 (10)

12/7/4

ME
12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-30-12 7:46:33 AM

Page 1

Work Order ID: 82386

82386

Parent Item: D2666-1

D2666-1

Parent Item Name: Saddle, LH Fwd Aft In 206

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	27.0000	1	4			

D6101-001

Saddle Billet

**

Location

Loc Qty

Loc Code

MAT040

3

69677

2

76836

1

MAT041

24

80764

24

85433

10

FK 12/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 82386	
Description: 206 Saddle, Inboard, Left side				Part Number: D2666-1	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.123	.123	.122	0.119	0.118
B	0.100	0.140		.103	.106	.106	0.105	0.105
C	2.470	2.510		2.492	2.492	2.492	2.492	2.490
D	0.100	0.180		.135	.135	.135	0.135	0.135
E	0.210	0.230		.222	.223	.223	0.215	0.217
F	1.313	1.343		1.325	1.325	1.325	1.321	1.321
G	0.240	0.260		.258	.253	.253	0.251	0.251
H	0.615	0.685		.627	.635	.635	0.635	0.635
I	1.125	1.145		1.129	1.135	1.135	1.135	1.135
J	0.990	1.010		1.006	1.002	1.002	1.003	1.003
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238
L	0.510	0.515		0.512	0.512	0.512	0.512	0.512
M	0.100	0.120		0.110	0.110	0.110	0.110	0.110
N	1.565	1.585		1.569	1.573	1.574	1.574	1.574
O	5.990	6.010		6.000	5.998	5.998	5.998	5.998
P	1.245	1.255		1.250	1.250	1.250	1.249	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		.498	.498	.498	0.497	0.497
S	0.312	0.318		.314	.314	.314	0.313	0.314
T	2.495	2.505		2.500	2.500	2.500	2.500	2.499
U	1.357	1.367		1.362	1.362	1.362	1.362	1.361
V	0.315	0.322		.316	.316	.316	0.317	0.317
W	0.540	0.560		.550	.550	.550	0.547	0.547
X	1.674	1.684		1.679	1.679	1.679	1.678	1.679
Y	0.256	0.262		.258	.258	.258	0.258	0.259
Z	0.178	0.198		.188	.188	.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: F.K.	Date: 12/06/25
Audited by: J.S.	Date: 12-06-28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	MA

DART AEROSPACE LTD		Work Order:	82386
Description: 206 Saddle, Inboard, Left side		Part Number:	D2666-1
Inspection Dwg: D2666 Rev: D DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1 6	2 7	3 8	4 9	5 10
A	0.100	0.140		0.118	0.118	0.118	0.121	0.121
B	0.100	0.140		0.104	0.104	0.104	0.103	0.101
C	2.470	2.510		2.491	2.490	2.490	2.490	2.490
D	0.100	0.180		0.135	0.135	0.135	0.135	0.135
E	0.210	0.230		0.217	0.217	0.220	0.218	0.220
F	1.313	1.343		1.322	1.320	1.324	1.322	1.322
G	0.240	0.260		0.252	0.252	0.250	0.250	0.253
H	0.615	0.685		0.635	0.635	0.635	0.635	0.635
I	1.125	1.145		1.132	1.135	1.139	1.136	1.137
J	0.990	1.010		1.003	1.003	1.003	1.003	1.003
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238
L	0.510	0.515		0.512	0.512	0.512	0.512	0.512
M	0.100	0.120		0.110	0.110	0.110	0.110	0.110
N	1.565	1.585		1.570	1.574	1.576	1.575	1.575
O	5.990	6.010		5.997	5.998	5.998	5.998	5.998
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		0.496	0.496	0.498	0.497	0.499
S	0.312	0.318		0.314	0.314	0.314	0.314	0.314
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.363	1.362	1.362	1.362	1.362
V	0.315	0.322		0.317	0.317	0.317	0.317	0.317
W	0.540	0.560		0.548	0.548	0.548	0.547	0.549
X	1.674	1.684		1.678	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: PO	Date: 12/06/26
Audited by: SL	Date: 12-06-28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
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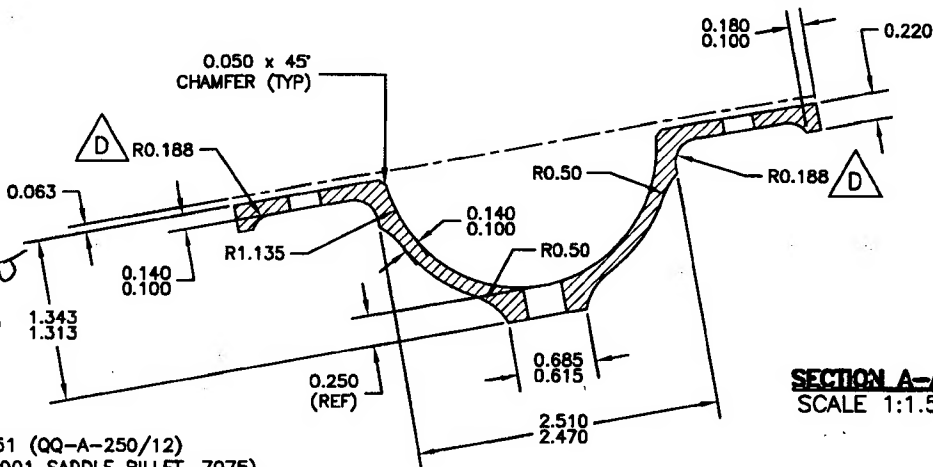


DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

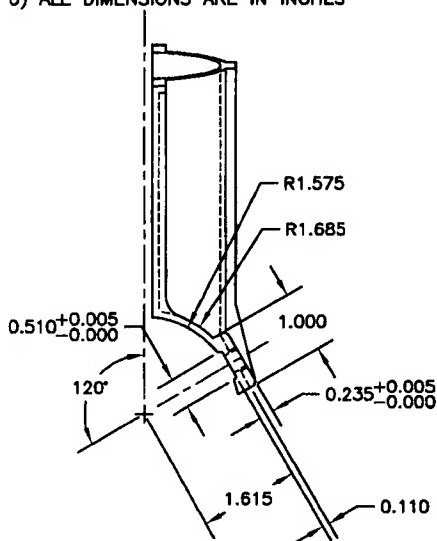
07 02 12 [Signature]

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82386 MWS
12/03/30

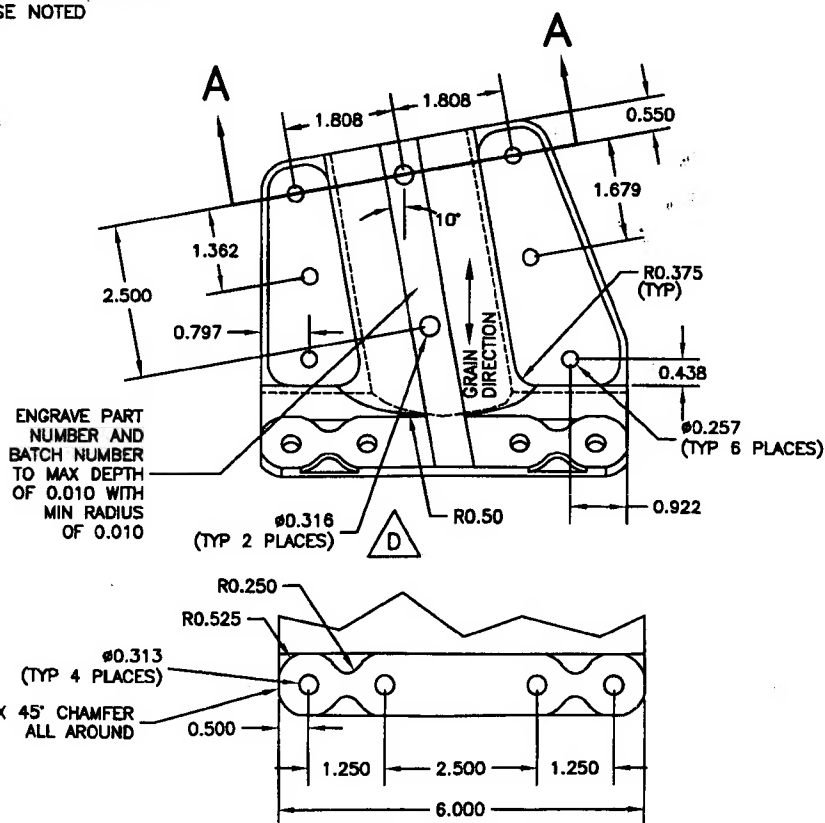


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



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